

Date: Monday, 12/01/2009 2:30:32 PM
User: Julie Dawson

Gray

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 44564
Estimate Number : 11093
P.O. Number :
This Issue : 12/01/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : LARGE FAB ASSY
Previous Run : 43561
Written By :
Checked & Approved By : JUD 09.01.12
Comment : Est. C 02.01.23 Revised NG
Est Rev:D 08-04-16 now water jet DD verified by:EC

Drawing Name : BACK PANEL
Part Number : D30231
Drawing Number : D3023 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 30/01/2009 **Qty:** 1 **Um:** Each

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M2024T3S032 2024-T3 .032 sheet



Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)
2024-T3 .032 sheet
Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
Batch: 110778 HB 9-2-16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3023
Dwg Rev: A HB 9-2-16
Prog Rev: A
****graind direction along 28.100" ****
2-Deburr if necessary HB 9-2-16

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/02/10 (H)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Bend as per Dwg D3023

S 09/02/25

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:30:32 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK PANEL

Job Number: 44564

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form edge of back pan as per dwg D3023 using D3017-041 back frame -

EL 9-2-25

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/25 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 02-02-26

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00am

BR 09-02-24

(X1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-02-26

(1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

BR 09-02-26

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



MF
09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H45621
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

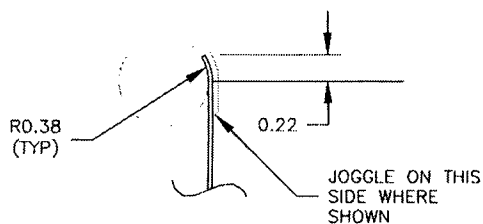
☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.129	x			
Ø0.191	+0.005/-0.001	.196	x			
1.660	+/-0.010	1.658	b			
0.375	+/-0.010	.374	x			
1.340	+/-0.010	1.336	x			
2.375	+/-0.010	2.375	x			
0.375	+/-0.010	.373	x			
25.28	+/-0.030	25.28	x			
27.03	+/-0.030	27.03	x			
28.10	+/-0.030	28.10	b			
1.30	+/-0.030	1.292	x			
2.375	+/-0.010	2.374	x			
8.711	+/-0.010	8.712	x			
5.597	+/-0.010	5.595	x			
8.57	+/-0.030	8.57	x			
1.970	+/-0.010	1.973	x			
7.42	+/-0.030	7.420	x			
10.92	+/-0.030	10.920	x			
14.75	+/-0.030	14.75	x			

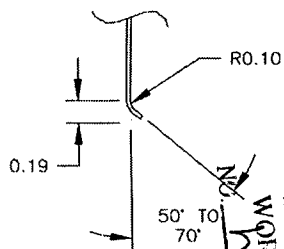
Measured by: VB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-16	Date: 09/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)

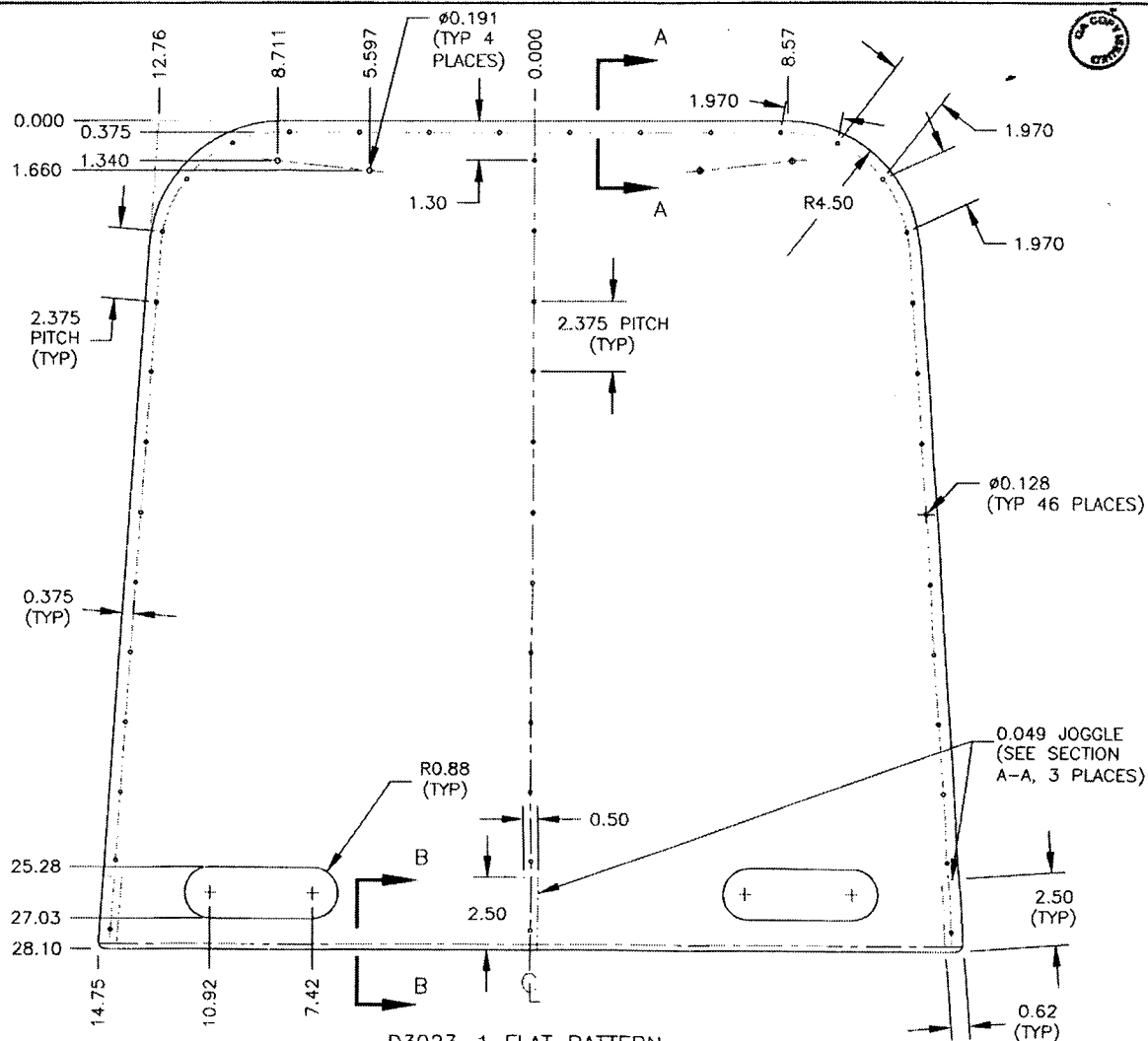


RELEASED
9.06.07

NO WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SK. COPY
RETURN TO
ENGINEERING

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

29.5 21.84 14.84

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. HAVERSHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4